

Work Order ID 108948

October-30-13 9:54:47 AM

Ship Nov 5

108948

~~PRELIMINARY ISSUE~~

Page 1

Item ID: D412-786-025

Accept

N900040100

Setup Start *NS1*

Revision ID: PRELIM

Stop *NS2*

Item Name: Tailboom Mount

Start Date: 10/30/13 Start Qty: 3.00 *3*

Cust Item ID:

Required Date: 11/04/13 Req'd Qty: 3.00 *3*

Customer:

Reference:

Approvals: Process Plan: W Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-786-1	<u>13-668</u> <u>PLR ECN 13-10-31</u>								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D412-786-025 chg001								
									DAS 27 9-89 3 B110Y
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
									DAS 32 9-89 13/10/31 (3)
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									
									DAS 27 9-89 3 B110Y

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Page 2

Item ID: D412-786-025

Accept

N900040100

Setup Start ***NS1***

Revision ID: PRELIM

Stop ***NS2***

Item Name: Tailboom Mount

Start Date: 10/30/13 Start Qty: 3.00 ***3***

Cust Item ID:

Required Date: 11/04/13 Req'd Qty: 3.00 ***3***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00			DAS 6 9-89	13/11/4		(3)	
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-786-025								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

13/11/4 *[Signature]*

per ECN 13-668
POSITIVE RECALL
EFFECTIVE 13-10-30 AUTH *[Signature]*
RELEASED

Picklist Print

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Page 1

Work Order ID: 108948
Parent Item: D412-786-025
Parent Item Name: Tailboom Mount

Start Date: 10/30/13
Start Qty: 3.00

Required Date: 11/04/13
Required Qty: 3.00

Comments: IPP REV:A NEW ISSUE 13-10-30 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued DAS	Status
NAS1149D0332J Washer		Purchased	No				Each	561.0000	29	72	-	32 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST293				7					
				125268				7					
				ST294				554					
				122973				75					
				125044				8					
				m125807				471					
D4950-041 Tailboom Mount		Manufactured	No				Each	0.0000		M 125807		DAS 32 9-89	
D4950-043 Tailboom Mount		Manufactured	No				Each	2.0000		108249		DAS 28 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				prelim				2		B 108950		DAS 32 9-89	
				107464				2					
MS2104213 Nut		Purchased	No				Each	5,075.0000	112	36		DAS 32 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST314				1035					
				M126036				35					
				M127304				1000					
				ST506				814					
				123900				814					
				ST510a				3226					
				M126275				8					
				M126333				3218					

13/10/30 (3)

M126 333

Picklist Print

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Page 2

Work Order ID: 108948

Parent Item: D412-786-025

Parent Item Name: Tailboom Mount

Start Date: 10/30/13

Required Date: 11/04/13

Start Qty: 3.00

Required Qty: 3.00

MS27039-1-11

Purchased

No

Each

832.0000

Screw

88-6
27
DAS

3A

Location

Loc Qty

Loc Code

GA	33	
9662	33	
ST305	72	
123352	72	
ST306	427	
123352	27	
125654	400	
ST506	300	
124326	300	

12

36

DAS
32
9-89

13/10/31 (3)

125654

DAS
31
9-89

FWD UPPER HARDPOINT
SEE FIGURE 2

FWD HARDPOINTS
SEE FIGURE 1

RH TAILBOOM MOUNTS
SEE FIGURES 3 & 5

LH TAILBOOM MOUNTS
SEE FIGURES 4 & 6

D412-786-011 /-021 HARDPOINT KIT

QTY -011	QTY -013	QTY -015	QTY -021	QTY -025	PART NUMBER	DESCRIPTION
X					D412-786-011	HARDPOINT KIT
1	X		1		D412-786-013	FWD HARDPOINT KIT
1		X			D412-786-015	TAILBOOM MOUNT KIT
			X		D412-786-021	HARDPOINT KIT
			1	X	D412-786-025	TAILBOOM MOUNT KIT
		1			D3866-041	TAILBOOM MOUNT
		2			D3866-043	TAILBOOM MOUNT
	1				D3870-041	FWD LH HARDPOINT
	1				D3870-042	FWD RH HARDPOINT
	1				D3870-5	FWD UPPER HARDPOINT
	1				D3871-1	DOUBLER
	1				D3871-2	DOUBLER
					D4950-041	TAILBOOM MOUNT
					D4950-043	TAILBOOM MOUNT
	10	12		12	MS21042E3	NUT
	8	12		12	MS27039-1-11	SCREW
	1				MS27039-1-12	SCREW
	1				MS27039-1-14	SCREW
	10	24		24	NAS1149D0332J	WASHER

INSTALLATION	WEIGHT	LONGITUDINAL		LATERAL	
		ARM	MOMENT	ARM	MOMENT
D412-786-011 HARDPOINT KIT	0.58 LBS 0.26 KG	164.67 IN 4.18 M	95.51 IN-LB 1.08 KG-M	-1.25 IN -0.03 M	-0.73 IN-LB -0.008 KG-M
D412-786-013 FWD HARDPOINT KIT	0.22 LBS 0.10 KG	-13.55 IN -0.34 M	-2.98 IN-LB -0.03 KG-M	2.38 IN 0.06 M	0.52 IN-LB 0.006 KG-M
D412-786-015 TAILBOOM MOUNT KIT	0.38 LBS 0.16 KG	273.58 IN 6.95 M	98.49 IN-LB 1.11 KG-M	-3.47 IN -0.09 M	-1.25 IN-LB -0.01 KG-M
D412-786-021 HARDPOINT KIT	0.64 LBS 0.29 KG	164.67 IN 4.18 M	105.39 IN-LB 1.21 KG-M	-1.25 IN -0.03 M	-0.08 IN-LB -0.01 KG-M
D412-786-025 TAILBOOM MOUNT KIT	0.42 LBS 0.19 KG	273.58 IN 6.95 M	114.90 IN-LB 1.32 KG-M	-3.47 IN -0.09 M	-1.48 IN-LB -0.02 KG-M

- NOTES:
- 1) D412-786-011/-021 HARDPOINT KIT REQUIRED ON 412/412EP AIRCRAFT UTILIZING D412-895-011 BLADE FOLDING KIT WHERE WIRE STRIKE COMPATABILITY IS REQUIRED
 - 2) D412-786-021 HARDPOINT KIT REQUIRED ON AIRCRAFT EQUIPPED WITH BLR TAILBOOM STRIKE KIT.
 - 3) TOUCH UP DRILLED HOLES WITH ALODINE PER THE AIRCRAFT MAINTENANCE MANUAL
 - 4) TORQUE FASTENERS AS FOLLOWS: 10-32; 20-25 IN-LBS
 - 5) PRIME AND PAINT HARDPOINTS TO MATCH AIRCRAFT PAINT SCHEME PER AIRCRAFT MAINTENANCE MANUAL

B	ADD -021/-025 KITS, SHEETS 6 & 7	DB	13.10.17
A	NEW ISSUE	DB	09.01.14
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	DB		
CHECKED	A.P.		
MFG. APPR.	N/A		
APPROVED			
DE APPR.			
DATE	13.10.17		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D412-786-1** REV. B
TITLE **HARDPOINT KIT INSTALL** SHEET 1 OF 7
SCALE NTS

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October-30-13 9:54:47 AM

Ship Nov. 5

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REWORK ISSUE

Page 1

Item ID: D412-786-025

Revision ID: PRELIM

Item Name: Tailboom Mount

Start Date: 10/30/13 Start Qty: 3.00

Required Date: 11/04/13 Req'd Qty: 3.00

3

3

Cust Item ID:

Customer:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Reference:

Run Start *NR1*

Approvals:

Process Plan: 

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D412-786-1

0.00

100

100


DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels per PPP D412-786-025 chg001 

MLJ 13-10-31

3

110

110

Packaging

Packaging

Pick Kit

0.00

Memo

0.00

120

120

QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00